

Date: Friday, 23/01/2009 8:46:24 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT STRUT ASSEMBLY
Job Number	: 45183		
Estimate Number	: 11286		
P.O. Number	:	Part Number	: D3437041
This Issue	: 23/01/2009 S.O. No. :	Drawing Number	: D3437 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 44582	Material	:
Written By	:	Due Date	: 05/02/2009 Qty: 8 Um: Each
Checked & Approved By	: <u>JLD 09.01.23</u>		
Comment	: Est. A 05.05.20 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34371	Foot
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Foot

Pick:

Qty	Part Number	Description	Batch
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1	D3437-1	Foot	<u>B44585</u>
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Ep 09/03/10

2.0	D34373	Clip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
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1	D3437-3	Clip	<u>B43175</u>
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Ep 09/03/10

3.0	D343711	Eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Eye Bolt

Pick:

Qty	Part Number	Description	Batch
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1	D3437-11	Eye Bolt	<u>B39893</u> (72)
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345282 (1K)

Ep 09/03/10

4.0	MS210435	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Self Locking Nuts

Pick:

Qty	Part Number	Description	Batch
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1	MS21043-5	Self Locking Nut	<u>M109535</u>
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*

Ep 09/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:46:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 45183

Part Number: D3437041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3437

Dwg Rev: B

25/09/03/10 (8)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

25 09/03/10 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST508

SS 09/03/11 (K8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



U 09.03.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

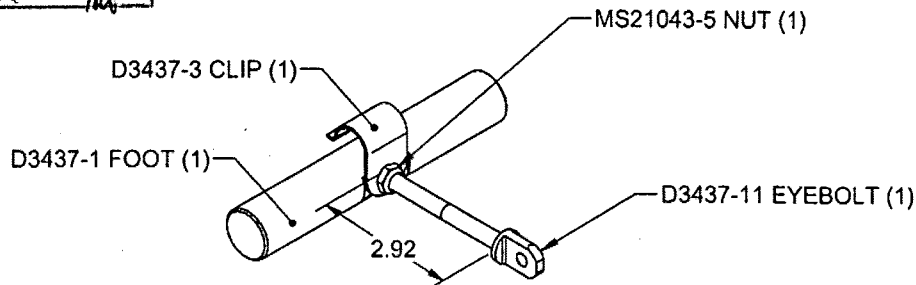
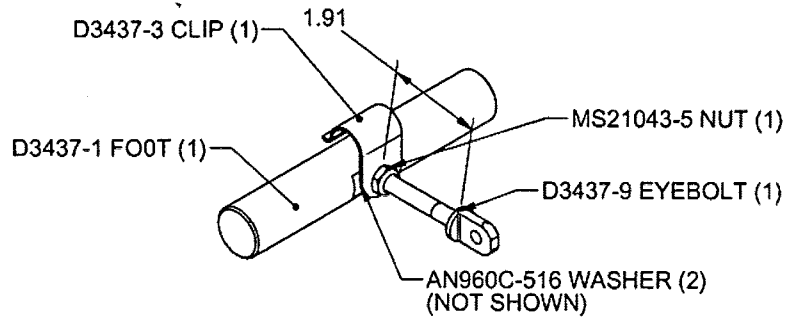
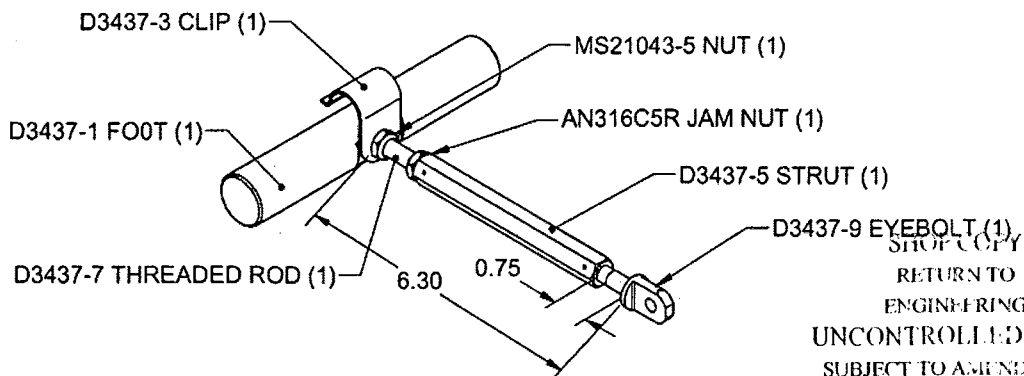
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED05.08.16 *[Signature]***D3437-041 AFT STRUT ASSEMBLY****D3437-043 AFT STRUT ASSEMBLY****D3437-045 AFT STRUT ASSEMBLY**

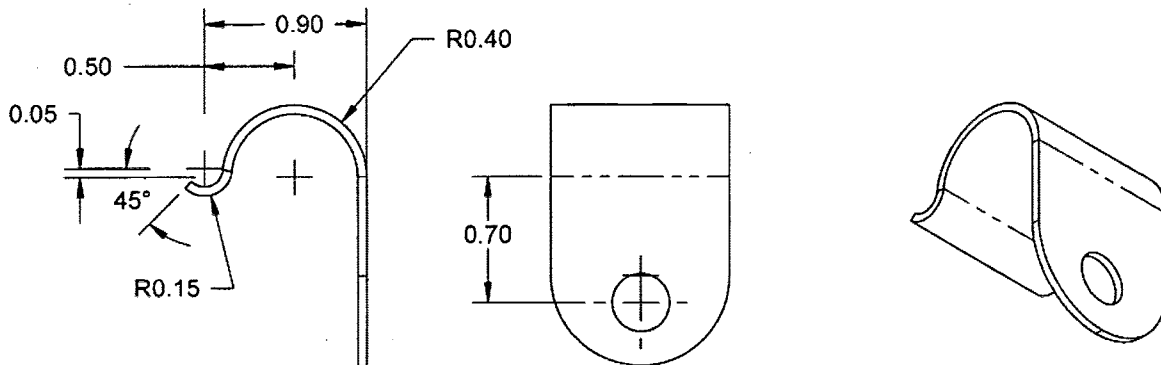
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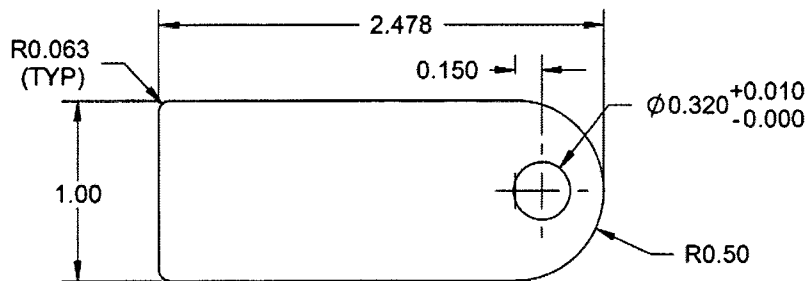
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED05.08.16 *[Signature]*

D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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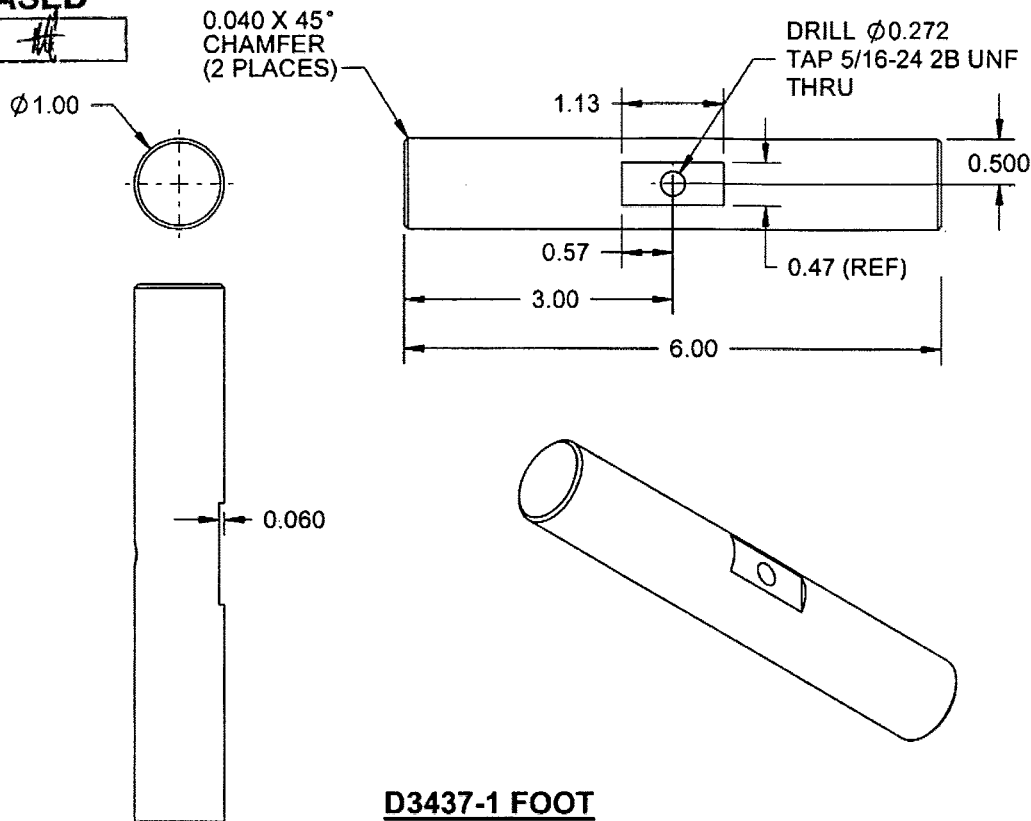
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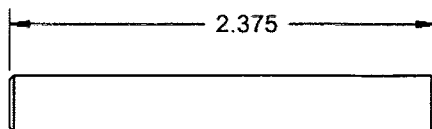
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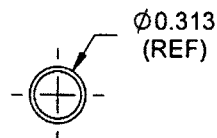
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED05.08.16 *[Signature]***D3437-1 FOOT****D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3437-7 THREADED ROD****D3437-7 THREADED ROD:**

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD/OUT NUT
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



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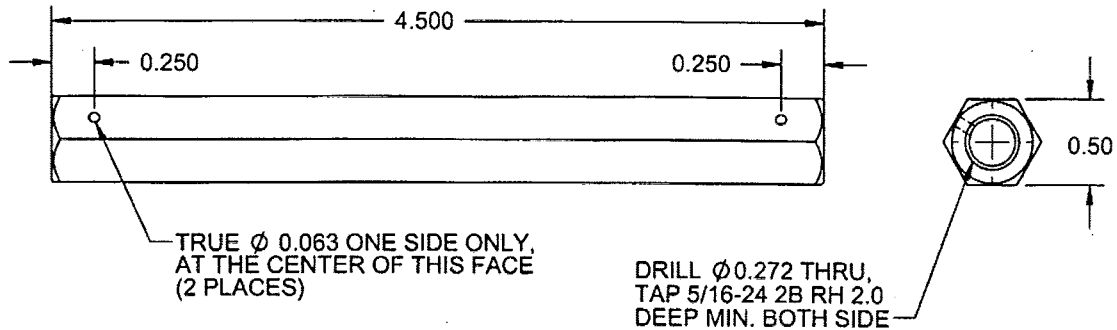
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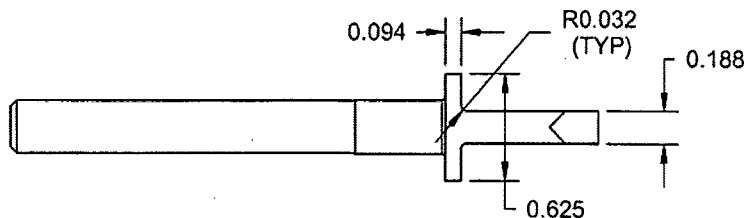
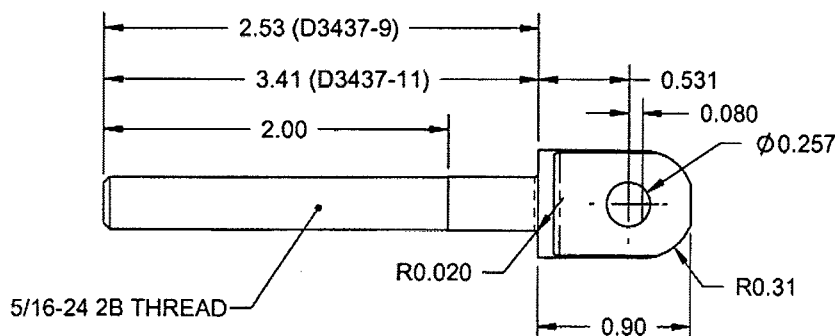
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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**05.08.16 *[Signature]***D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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